

What is claimed is:

1. A thermoplastic multi-layer film for forming hermetic seals on packages comprising:
- (a) layer B comprising polypropylene and a softening additive;
  - (b) layer C comprising a copolymer.
2. The film of claim 1, wherein the copolymer of layer C is selected from the group consisting of ethylene-propylene copolymer, ethylene-propylene-butene-1 terpolymer, propylene-butene copolymer, and mixtures thereof.
3. The film of claim 1 further comprising layer A comprising a material selected from the group consisting of high density polyethylene, medium density polyethylene, and mixtures thereof.
4. The film of claim 1 wherein the softening additive in layer B comprises a material selected from the group consisting of ethylene-propylene copolymers, terpolymers, thermoplastic hydrocarbons, hydrocarbon resins, and cyclopentadiene hydrocarbon.
5. The film of claim 1 wherein the softening additive in layer B comprises a hydrocarbon resin.
6. The film of claim 1 wherein the softening additive in layer B comprises cyclopentadiene hydrocarbon.
7. The film of claim 1 wherein the softening additive in layer B comprises from about 2% to about 15% by weight of layer B.
8. The film of claim 5 wherein the softening additive in layer B comprises from about 2% to about 15% by weight of layer B.
9. The film of claim 6 wherein the softening additive in layer B comprises from about 2% to about 15% by weight of layer B.
10. The film of claim 1, wherein the layer C thickness is from about 5 microns to about 10 microns.
11. The film of claim 1, wherein the thickness of the film is from about 17 microns to about 31 microns.
12. The film of claim 3, wherein the thickness of the film is from about 17 microns to about 31 microns; the layer C thickness is from about 5

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microns to about 10 microns; the layer B thickness is from about 5 microns to about 25 microns; and the layer A thickness is from about 1 micron to about 10 microns.

13. The film of claim 1, wherein the film is biaxially oriented.
- 5 14. The film of claim 1, wherein the film is uniaxially oriented.
15. The film of claim 1, wherein the film is hermetically sealable in a machine for making packaging bags with a combination of a fin seal and crimp seals or a combination of a lap seal and crimp seals.
16. The film of claim 3, wherein the layer A is metallized.
- 10 17. The film of claim 3, wherein the layer A comprises high density polyethylene.
18. The film of claim 3, wherein the layer A comprises medium density polyethylene.
19. The film of claim 3 further comprising a coating applied to the layer A.
- 15 ~~20.~~ A thermoplastic multi-layer film for forming hermetic seals on packages comprising:
- (a) layer B comprising polypropylene and a softening additive wherein layer B has a first side and a second side;
- (b) layer C comprising a copolymer wherein layer C has a first side
- 20 and a second side, wherein the first side of layer C is adjacent to the second side of layer B.
21. The film of claim 20 further comprising layer A comprising a material selected from the group consisting of high density polyethylene, medium density polyethylene, and mixtures thereof wherein layer A has a first side
- 25 and a second side wherein the second side of layer A is adjacent to the first side of layer B.
- ~~22.~~ A method of producing a thermoplastic multi-layer film comprising the steps of:
- (a) coextruding a first layer comprising; a second layer comprising
- 30 polypropylene and a softening; and a third layer comprising a copolymer;

(b) orienting the film in the machine direction at an elevated temperature.

23. The method of claim 22 further comprising the step of orienting said film in the transverse direction at an elevated temperature.
- 5 24. The method of claim 22 further comprising the step of corona said third layer.
25. The method of claim 22 further comprising the step of flame treating said third layer.
26. The method of claim 22 further comprising the step of plasma treating said third layer.
- 10 27. The method of claim 22 further comprising the step of priming said third layer.
28. The method of claim 22 wherein the film produced has a MST below 170 degrees fahrenheit.
- 15 29. The film of claim 1 wherein the film has a MST below 170 degrees fahrenheit.

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